

# Work Order ID 55050

January 5, 2010 1:51:30 PM



Page 1

Item ID: D3706-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lock Bracket

Start Date: 05/01/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

*Handwritten signature*

Date: 10-1-05

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3706

Rev A

100



BAND SAW

Memo

Cut blank 3.5" long

0.00

*Handwritten: H.A 10/4/13*

6

Ø

Bandsaw

0.00

Jcaspa Bandsaw

110



CONVENTIONAL MILLING MACHINE

Memo

1- Mill as per dwg D3706-2-Deburr as per dwg D3706

0.00

*Handwritten: H.A 10/01/13*

6

Ø

Mill Conv

0.00

Conventional Milling Machine

*Handwritten: HAAS #1*

*Handwritten: Jan 10.01.11*

120



QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

*Handwritten: H.A 10/01/13*

6

Ø

QC

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 55050**

Page 2

January 5, 2010 1:51:30 PM

Item ID: D3706-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lock Bracket

Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

10-01-14

6

Quality Control

140

Identify as per dwg &amp; Stock Location: 5784

0.00



Packaging

Memo

0.00

10-01-14 6

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/15  
MK  
10-1-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 5, 2010 1:51:34 PM

Page 1

Work Order ID: 55050



Parent Item: D3706-1



Parent Item Name: Lock Bracket

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M6061T6B0.750X01.50

Purchased

No

f

15.6756

1.8000

0



6061-T6 Bar .750 X 1.50

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

15.6755998

110167

15.6755998

1,8410 FT 19.A 10/01/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

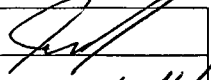
**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	55050
Description: LOCK BRACKET		Part Number:	D3706-1
Inspection Dwg: D3706 Rev: A		Page 1 of 1	

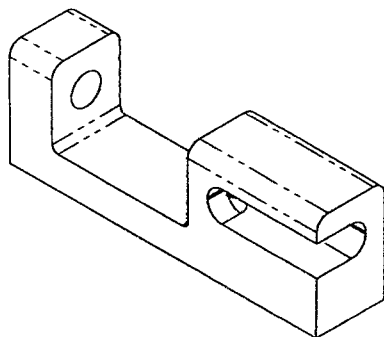
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

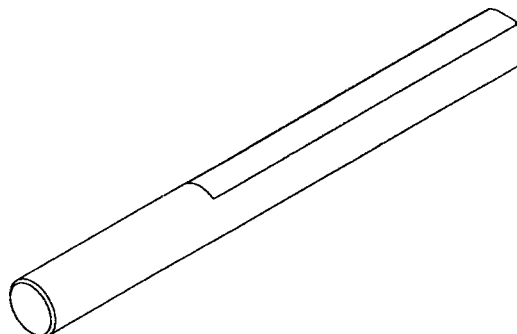
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.460	+/- .010	0.460	✓			
0.80	+/- .030	0.800	✓			
1.500	+/- .010	1.501	✓			
R0.13	+/- .030	R0.125	✓			
Ø 0.328	+0.006/-0.001	Ø 0.333	✓			
0.334	+/- .010	0.336	✓			
1.15	+/- .030	1.149	✓			
0.745	+/- .010	0.748	✓			
0.375	+/- .010	0.373	✓			
R0.156	+/- .010	R0.156	✓			
1.20	+/- .030	1.200	✓			
0.75	+/- .030	0.745	✓			
1.20	+/- .030	1.200	✓			
3.38	+/- .030	3.377	✓			

Measured by: H.A	Audited by: 	Prototype Approval:	N/A
Date: 10/01/13	Date: 10-01-14	Date:	N/A

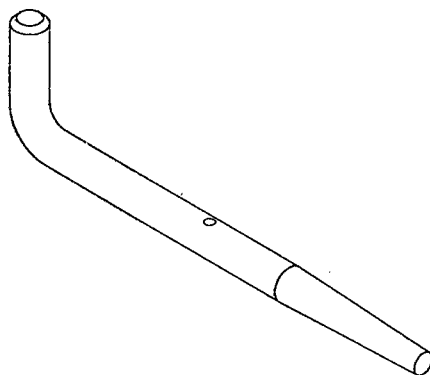
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3706-1 LOCK BRACKET



D3706-3 GUIDE



D3706-5 PIN

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 55050  
Pl 10-1-05

RELEASED  
07/02/05

A	NEW ISSUE	MS	06.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.26		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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TITLE INSTRUMENT PANEL LOCK	SCALE NTS
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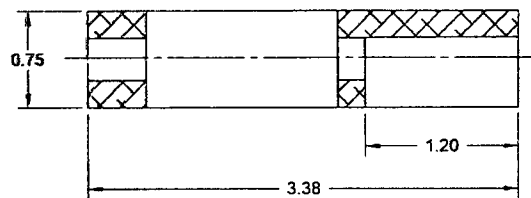
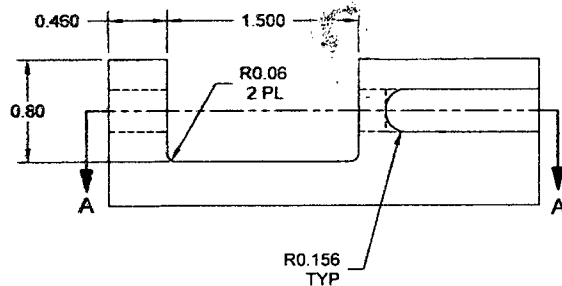
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

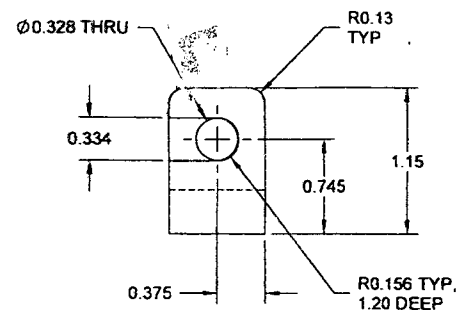
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# SECTION A-A

## D3706-1 LOCK BRACKET



### D3706-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.17 lbs

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8/12/05 NPB

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CHECKED		D3706	SHEET 2 OF 4
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DATE	08.05.26		

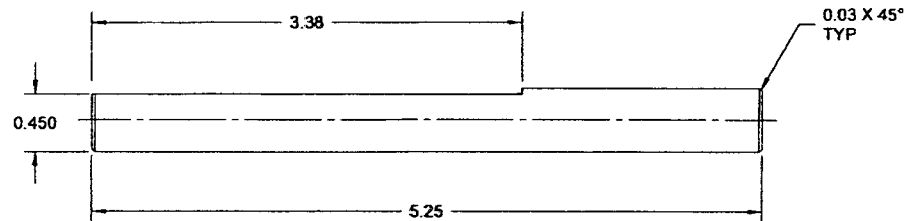
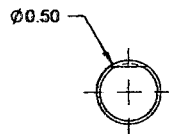
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# **D3706-3 GUIDE**

## **D3706-3 GUIDE NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) ALUMINUM ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF. DART SPEC. M6061T6R0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

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07/12/05

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MFG. APPR.		D3706	SHEET 3 OF 4
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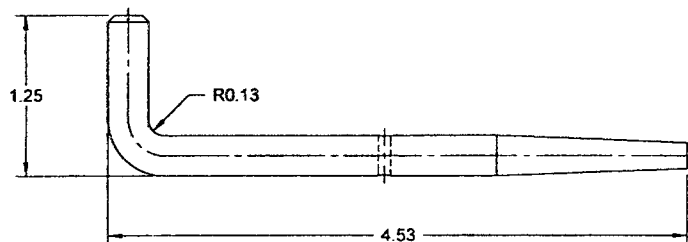
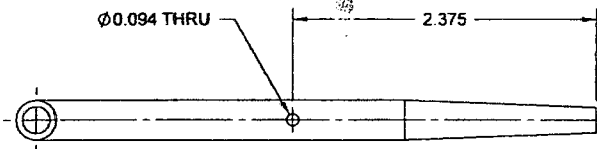
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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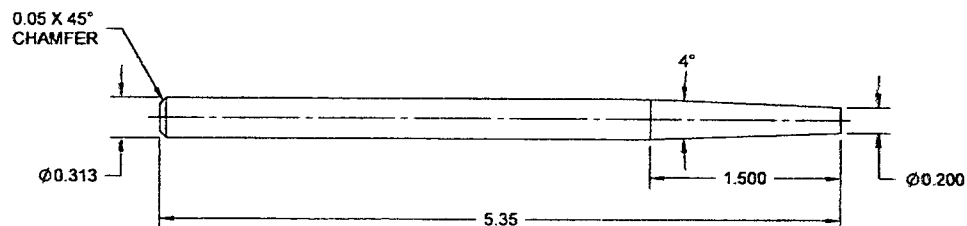
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3706-5 PIN**  
(MAKE FROM D3706-5F)



**D3706-5F PIN**

**D3706-5 NOTES:**

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR  
(REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries